

Date: Tuesday, 19/08/2008 4:04:20 PM  
 User: Julie Lecocq

## Process Sheet

|                       |   |                  |                               |
|-----------------------|---|------------------|-------------------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services             | Drawing Name     | : HINGE BRACKET               |
| Job Number            | : 41439   |                  |                               |
| Estimate Number       | : 10349   |                  |                               |
| P.O. Number           | :   | Part Number      | : D28582                      |
| This Issue            | : 19/08/2008 S.O. No. :                           | Drawing Number   | : D2858 REV B                 |
| Prsht Rev.            | : NC  | Project Number   | : N/A                         |
| First Issue           | : // Type : MACHINED PARTS                        | Drawing Revision | : B                           |
| Previous Run          | : 39788   | Material         | :                             |
| Written By            | :   | Due Date         | : 30/09/2008 Qty: 24 Um: Each |
| Checked & Approved By | : <u>JUL 08.8.19</u>                              |                  |                               |
| Comment               | : Est C 00.06.22 , Removed P/O for powder coat EC |                  |                               |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |                    |                         |
|-----|--------------------|-------------------------|
| 1.0 | M6061T6B1500X01250 | 6061-T6 Bar 1.50 x 1.25 |
|-----|--------------------|-------------------------|



Comment: Qty.: 0.1767 f(s)/Unit Total: 4.2412 f(s)  
 Material: 1.50" X 1.25"  
 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)  
 (M6061T6B15001250)  
 Batch M107461

*N.A 08/09/18*

|     |          |          |
|-----|----------|----------|
| 2.0 | BAND SAW | BAND SAW |
|-----|----------|----------|



Comment: BAND SAW  
 Cut blanks 6.02"  
 Note: 1 Blank Makes 3 Parts

*N.A 08/09/18*

|     |       |                                |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1  
 1-Machine per folio D2858-2  
 2-Deburr

*08/09/20*

|     |     |  |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*08/09/20 (25)*

Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: D2858-2 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 08/09/02  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: <u>41439</u> |           | WORK ORDER NON-CONFORMANCE (NCR)  |  |  |                              |                             |  |                             |
|-------------------|-----------|---|--|--|------------------------------|-----------------------------|--|-----------------------------|
| DATE              | STEP      | Description of NC<br>Section A  | Corrective Action Section B                              |  |                              | Verification<br>Section C   | Approval<br>Chief Eng                                    | Approval<br>QC Inspector    |
|                   |           |   | Initial<br>Chief Eng                                     | Action Description<br>Chief Eng  | Sign &<br>Date               |                             |  |                             |
| <u>08.09.02</u>   | <u>30</u> | <u>C' bore is 0.385".</u><br><u>suspected to be 0.400 +.005</u><br><u>R.C. operator error</u> | <u>AK</u><br><u>08.09.02</u><br><u>ASF</u><br><u>042</u> | <u>Parts Qty (25)</u><br><u>Are accepted</u><br><u>fasteners still fit</u> | <u>AK</u><br><u>08/09/02</u> | <u>S</u><br><u>08/09/02</u> | <u>AK</u><br><u>08.09.02</u><br><u>ASF</u><br><u>042</u> | <u>S</u><br><u>08/09/02</u> |
|                   |           |   |  |  |                              |                             |  |                             |
|                   |           |   |  |  |                              |                             |  |                             |

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:04:20 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 41439

Part Number: D28582

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

8/08/09/22

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

M.H. 08/09/22

(25X)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:30  
320 OF  
9:00

M.H. 08/09/24

(25X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

H.J.

08-09-24

(X25)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57

8/9/24

X85

54

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/26

Job Completion



u 08/09/25

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

|                                   |               |                             |
|-----------------------------------|---------------|-----------------------------|
| <b>DART AEROSPACE LTD</b>         |               | <b>Work Order:</b> 41439    |
| <b>Description:</b> Hinge Bracket |               | <b>Part Number:</b> D2858-2 |
| <b>Inspection Dwg:</b> D2858      | <b>Rev:</b> B | <b>Page 1 of 1</b>          |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.171            | +0.005/-0.000 | .171             |        |        |                      |          |
| Ø0.400            | +0.005/-0.000 | .395             |        | *      | See P15 Page ①       |          |
| R0.125            | +/-0.010      | R.125            |        |        |                      |          |
| 0.328             | +/-0.010      | .328             |        |        |                      |          |
| 0.820             | +/-0.005      | .820             |        |        |                      |          |
| 1.476             | +/-0.010      | 1.476            |        |        |                      |          |
| 0.342             | +/-0.010      | .342             |        |        |                      |          |
| 0.875             | +/-0.010      | .875             |        |        |                      |          |
| 1.56              | +/-0.030      | 1.56             |        |        |                      |          |
| 0.147             | +/-0.010      | .147             |        |        |                      |          |
| 0.717             | +/-0.010      | .717             |        |        |                      |          |
| 0.697             | +/-0.010      | .697             |        |        |                      |          |
| 0.229             | +/-0.010      | .229             |        |        |                      |          |
| R0.125            | +/-0.010      | R.125            |        |        |                      |          |
| R0.063            | +/-0.010      | R.063            |        |        |                      |          |
| 0.063             | +/-0.010      | .063             |        |        |                      |          |
| 0.126             | +/-0.010      | .123             |        |        |                      |          |
| 0.630             | +/-0.010      | .630             |        |        |                      |          |
| R0.354            | +/-0.010      | R.354            |        |        |                      |          |
| 0.965             | +/-0.010      | .965             |        |        |                      |          |
| Ø0.166            | +0.005/-0.000 | .166             |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |

|                                 |                                |                            |     |
|---------------------------------|--------------------------------|----------------------------|-----|
| <b>Measured by:</b> [Signature] | <b>Audited by:</b> [Signature] | <b>Prototype Approval:</b> | N/A |
| <b>Date:</b> 08/09/20           | <b>Date:</b> 08/09/22          | <b>Date:</b>               | N/A |

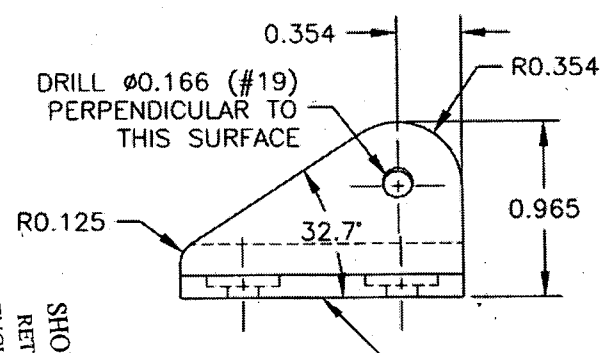
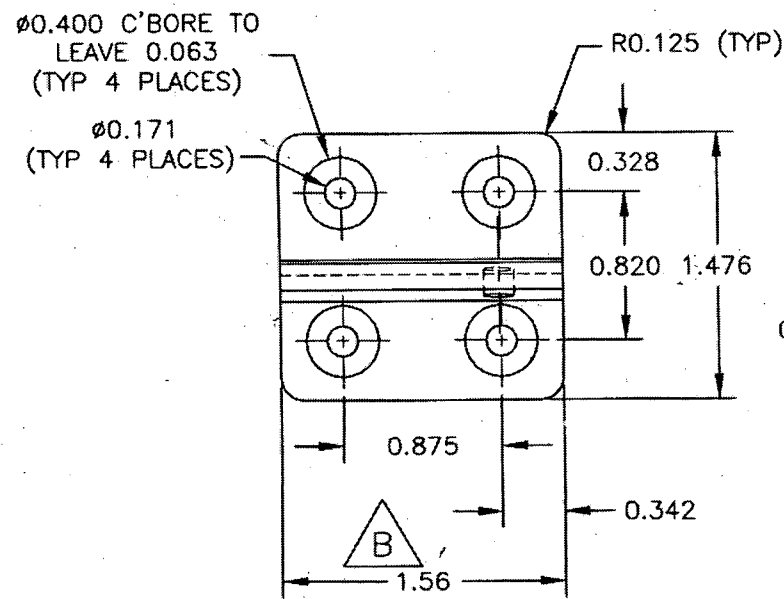
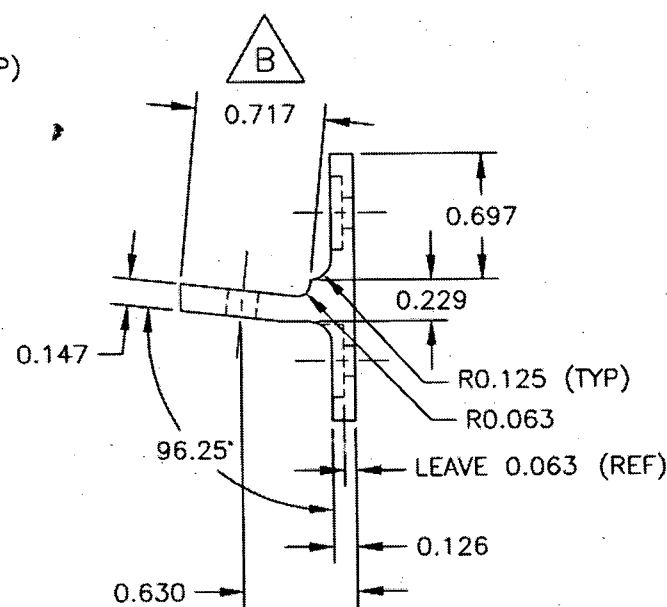
| Rev | Date     | Change    | Revised by         | Approved    |
|-----|----------|-----------|--------------------|-------------|
| A   | 04.11.11 | New Issue | KJ/JLM [Signature] | [Signature] |

**DART**

QA CONTROLLED

RELEASED  
99.02.03 KE

| DESIGN   | DRAWN BY                        | DART AEROSPACE LTD          |
|----------|---------------------------------|-----------------------------|
| KE       | KE                              | HAWKESBURY, ONTARIO, CANADA |
| CHECKED  | APPROVED                        | DRAWING NO.                 |
| UP       | KE                              | D2858                       |
| DATE     | TITLE                           | REV. B                      |
| 99.02.28 | HINGE BRACKET                   | SHEET 1 OF 1                |
| A        | 98.12.14                        | SCALE                       |
| B        | 99.02.28                        | 1:1                         |
|          | NEW ISSUE                       |                             |
|          | 0.717 WAS 0.667, 1.56 WAS 1.559 |                             |



ENGRAVE P/N CENTERED ON  
BASE 0.003 DEEP (0.010 MAX)

D2858-1 SHOWN  
D2858-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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